

order 10361

2 JAN



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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBE105-31702W4
Job Sheet 185653



Part No: RBE105-31702W4

Job Qty: 1 ea 5

Part Name: Pressing-In & Pressing-Out Tool



DAG
21
9-89

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 1/7/19 1/2/19

DAG
21
9-89

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31702W4 Rev.A. IPP Rev. A 18.10.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/7/19	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	1 pcs		1/7/19	0.00	1.00	Small Fab-3		MLC
120	QC	1 pcs		1/7/19	0.00	0.00	QC5		38
130	Packaging	1 pcs		1/7/19	0.00	0.00	Packaging3-1		MLC 9-89
140	QC21-FG	1 Ea		1/7/19	0.00	0.00	QC21		

Part Op 110 - 1-Assemble as per DWG.

Descriptions: 130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

JAN 24 2019
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
94895A817	Steel Hex Nut 7/16"-14 X 3/8" Thk.	1 (1 ea)	90-Start up Operation	5124967
98023A032	Steel Washer 0.469" ID. X 0.922" OD.	1 (1 ea)	90-Start up Operation	5124973
RBE105-31702W4-1	Bolt	1 Ea (1 ea)	110-Small Fab	5144912
RBE105-31702W4-2	Drawing In Disc	1 Ea (1 ea)	110-Small Fab	5139623
RBE105-31702W4-3	Support Body	1 Ea (1 ea)	110-Small Fab	5139623

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	94895A817	1	0	0
	98023A032	1	0	0
110-Small Fab	RBE105-31702W4-1 NLY	1	0	0
	RBE105-31702W4-2 NLY	1	0	0
	RBE105-31702W4-3 NLY	1	0	0



Container No: S147504



Part: RBE105-31702W4

Job No: 185653

Serial No/Batch: S147504

Revision: A

Inspector:

Exp Date:

Instructions:

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Plex 10/31/18 9:35 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



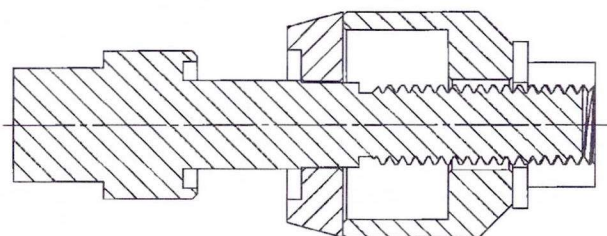
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE105-31702W4-1	BOLT
-2	1	RBE105-31702W4-2	DRAWING IN DISC
-3	1	RBE105-31702W4-3	SUPPORT BODY
4	1	McMaster#94895A817 OR EQUIV.	STEEL HEX NUT 7/16"-14 X 3/8" THK.
5	1	McMaster#98023A032 OR EQUIV.	STEEL WASHER 0.469" ID. X 0.922" OD.



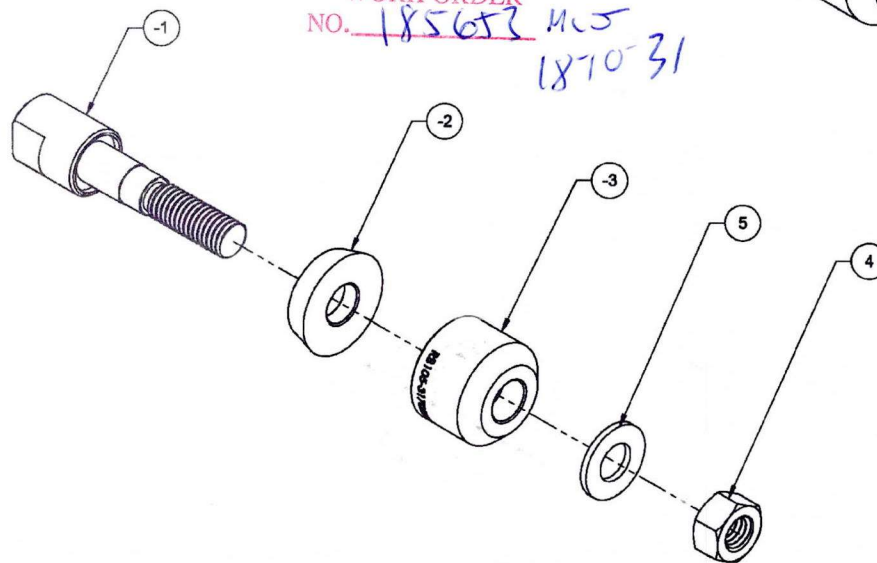
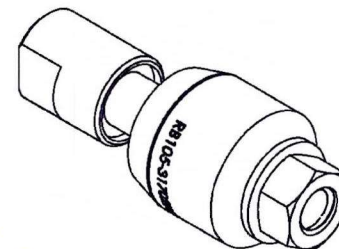
RBE105-31702W4 PRESSING IN & PUSHING OUT TOOL

9

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185653 MJS
1870-31



A	NEW ISSUE	18-836	KK
REV.	DESCRIPTION	ECN #	BY
DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	KK	TOOL PART #	REV. A
MFG. APPR.	FK	RBE105-31702W4	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/29/2018	PRESSING IN & PUSHING OUT TOOL	NTS
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